

Work Order ID 76453

76453

Page 1

Tuesday, November 15, 2011 9:20:50 AM

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 11/14/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference: REWORK TO REV I

Approvals: Process Plan: *MF* Date: *11-11-15* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3391	1

300 0.00
300
 Packaging Memo 0.00
 Packaging PULL FROM STOCK D3391-025 R73014
 AND BRING TO FINISHING

BR 11-11-17

310 0.00
310
 Skidtubes Memo 0.00
 Skidtubes REMOVE WEARPLATES AND PUT BACK INTO STOCK :
 REMOVE GASKETS AND SCRAP

1 BR 11-11-17

D3537-1 X 1
 D3537-7 X 1
 D3553-1 X 1
 D3553-3 X 1
 DISCARD HARDWARE AND PICK NEW
 RE-ASSEMBLE WITH NEW WEARPLATES AND NEW HARDWARE
To Rev I

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Page 2

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Aft Tube Assembly
 Start Date: 11/14/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference: REWORK TO REV I

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

320 QC5- Inspect part completeness to step on W/O
320
 QC
 Quality Control

0.00

0.00

S. W. 11/17

(Signature)

330 Identify as per dwg & Stock Location: _____
330
 Packaging
 Packaging

0.00

0.00

5/11/11

11/11/11

340
340
 QC
 Quality Control

0.00

0.00

Memo

11/11/11

11/11/11

Picklist Print

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Page 1

Work Order ID: 76453

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/14/2011

Required Date: 11/16/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H 11.11.14 AS PER REV.I
 DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-130		Purchased	No				Each	2,000.0000		14			
---------------	--	-----------	----	--	--	--	------	------------	--	----	--	--	--

Insert

Location	Loc Qty	Loc Code
ST280	1984	
119084	1984	
ST281	16	
117717	2	
118237	12	
118312	2	

ALS4-1032-225		Purchased	No				Each	2,181.0000		8			
---------------	--	-----------	----	--	--	--	------	------------	--	---	--	--	--

Insert

Location	Loc Qty	Loc Code
ST281	2181	
108696	285	
110768	62	
118386	858	
118966	976	

Picklist Print

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Work Order ID: 76453

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/14/2011

Required Date: 11/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No Each 2,101.0000

6

BOLT

BR 11-11-17

Location	Loc Qty	Loc Code
ST350	2101	
117313	2	
117688	5	
117872	22	
118112	16	
118451	2	
118706	92	
118838	962	
119328	1000	

AN3C5A Purchased No Each 987.0000

4

Bolt

BR 11-11-17

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	980	
116419	28	
117343	17	
117764	166	
117872	2	
118451	267	
119127	500	

AN960C10L washer * NAS1149C0332R Purchased No Each 0.0000

10

118354.

10 BR 11-11-17

Picklist Print

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Work Order ID: 76453

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/14/2011

Required Date: 11/16/2011

Start Qty: 1.00

Required Qty: 1.00

~~D3646~~

~~Aft Cap~~

Manufactured No

Each 243.0000

1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	226	
73294	26	
73825	200	
FP004	5	
68280	5	
FP006	5	
62678	5	
FP-4	3	
70945	1	
71070	2	
fp5	4	
71038	4	

~~D3537-1~~

~~Wearpad~~

Manufactured No

Each 80.0000

-1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	73	
74436	56	
74597	17	
FP017	7	
69817	5	
70686	2	

~~D3537-7~~

~~Wearpad~~

Manufactured No

Each 19.0000

-1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	4	
71689	4	
FP001	12	
74617	12	
FP017	3	
71689	3	

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 76453

Parent Item: D3391-025

Start Date: 11/14/2011

Required Date: 11/16/2011

Parent Item Name: Aft Tube Assembly

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

Each 104.0000

4

SPACER

N/A

Location

Loc Qty

Loc Code

LG

12

71850

12

LG001

92

72851

92

D3672-1

Manufactured No

Each 688.0000

2

Phenolic Washer

Location

Loc Qty

Loc Code

FP-A

424

52505

0

66821

424

ST074

264

72229

264

D4095-047

Manufactured No

Each 0.0000

Wearpad Assembly

76208.

① 15211-11-17.

D4095-049

Manufactured No

Each 0.0000

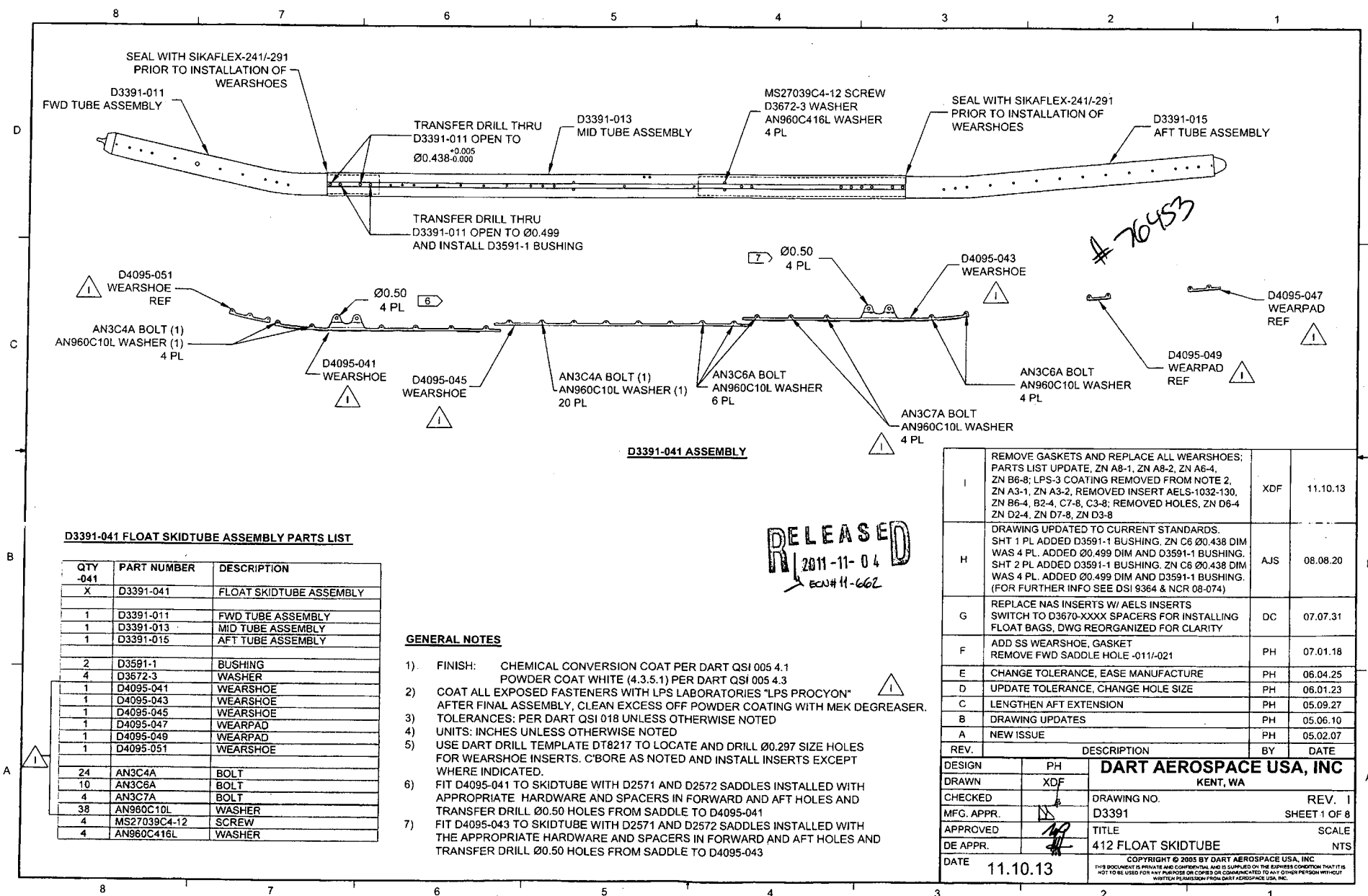
Wearpad Assembly

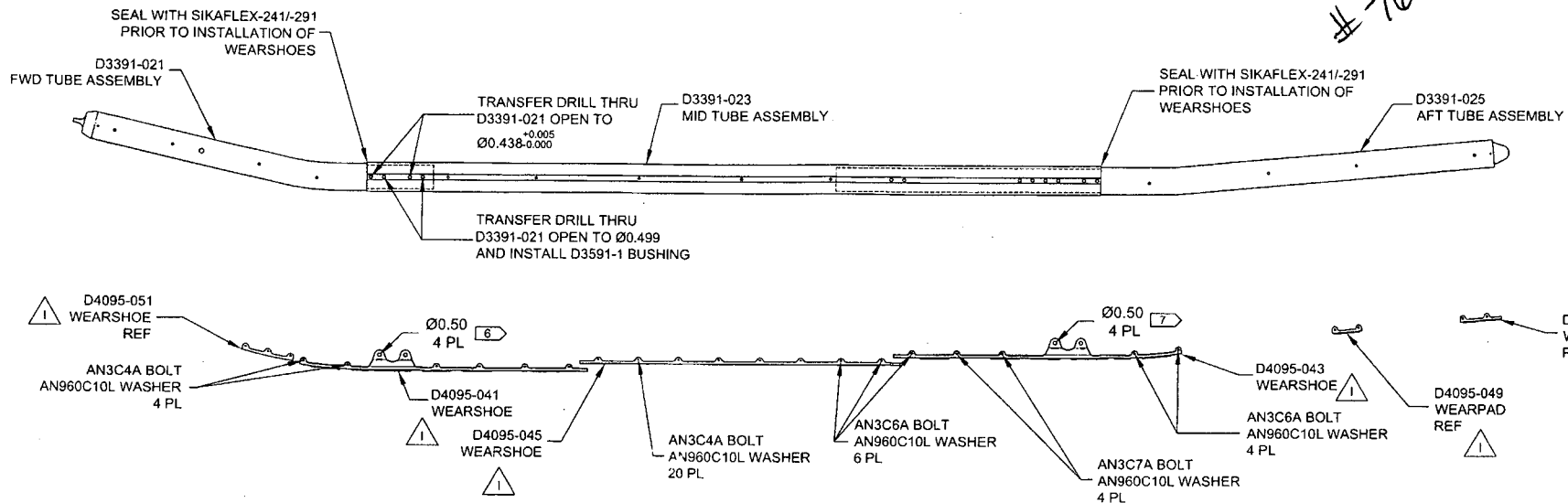
76217.

① 15211-11-17.

D3391-025

① 73014. 15211-11-17.





D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

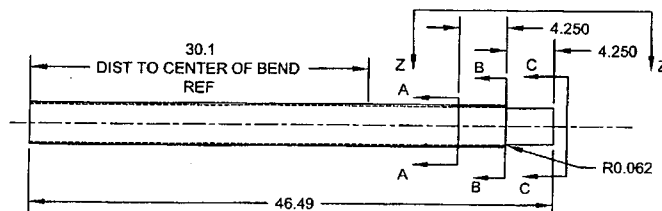
QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

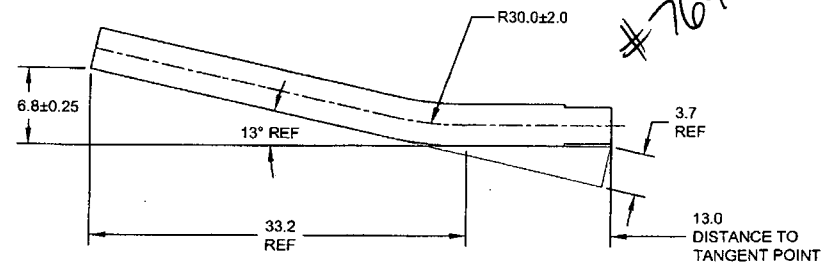
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04

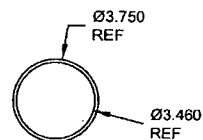
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DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 2 OF 8
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DE APPR.		412 FLOAT SKIDTUBE	NTS
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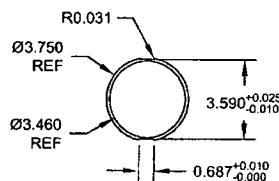
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



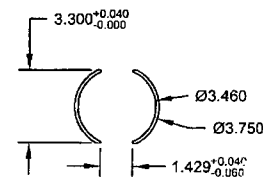
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



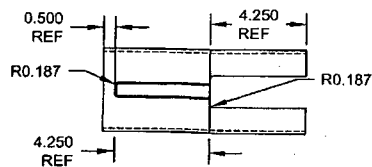
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



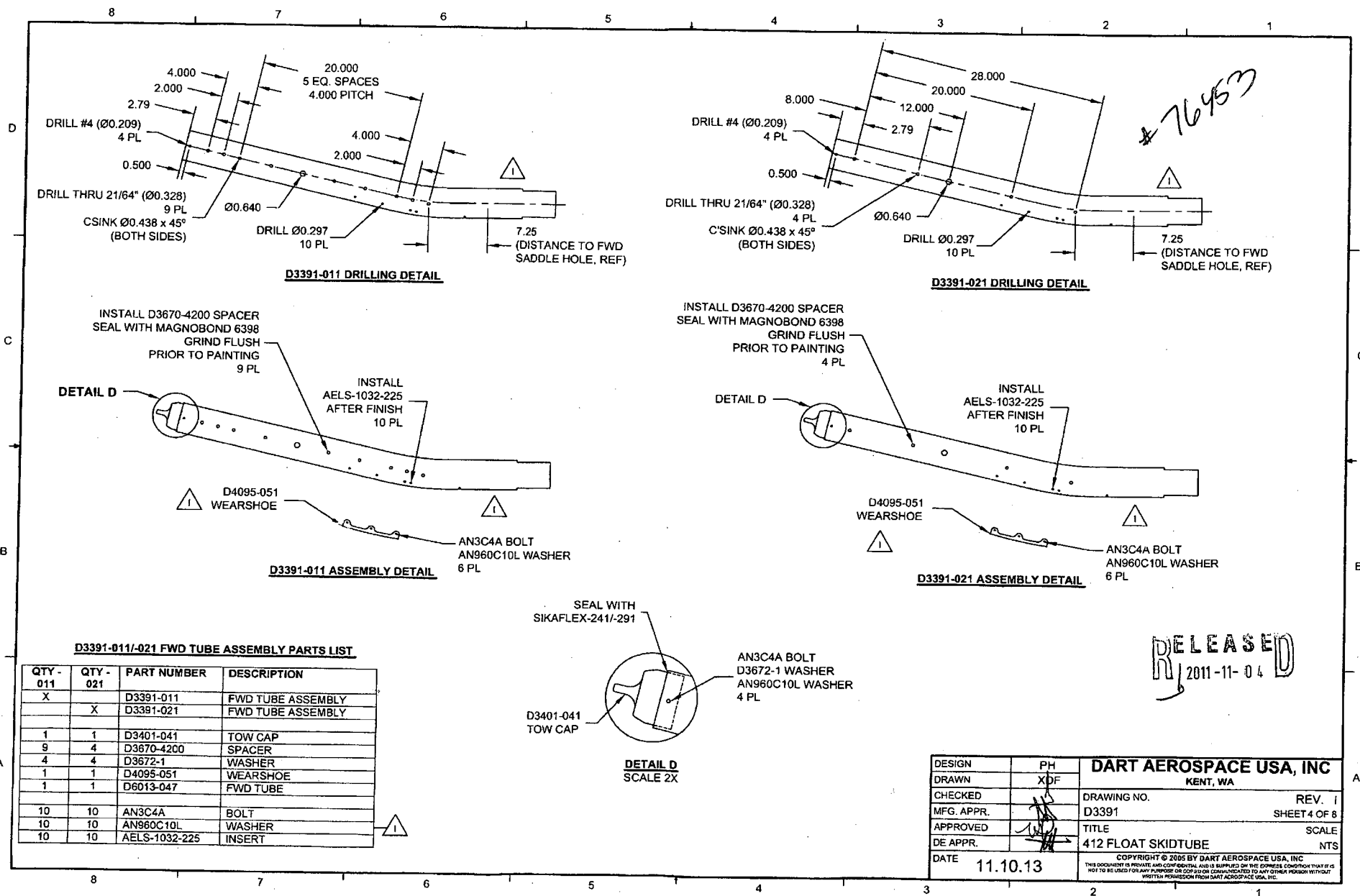
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SCALE 2X



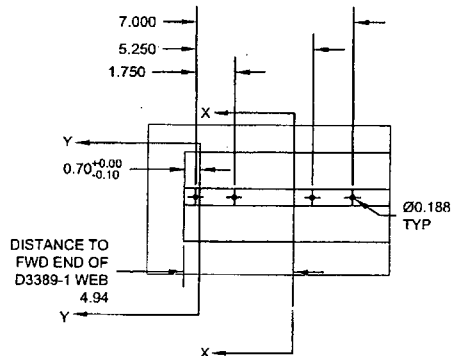
VIEW Z-Z
SCALE 2X

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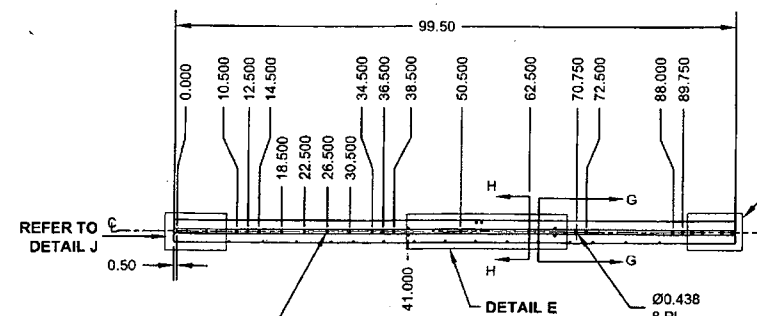
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MFG. APPR.				D3391	SHEET 3 OF 8
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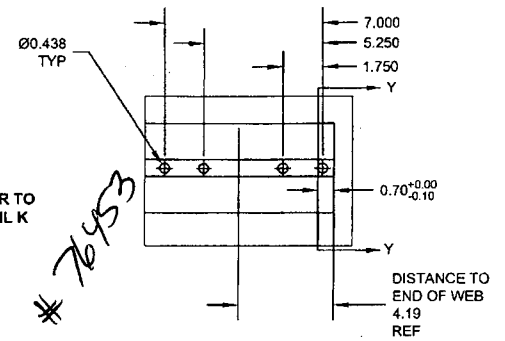
8 7 6 5 4 3 2 1



DETAIL J
SCALE 4X



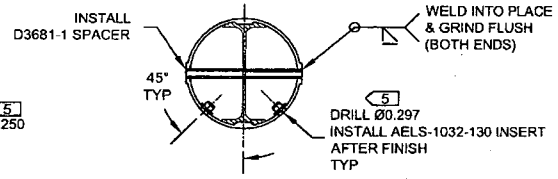
D3391-013 ASSEMBLY DETAIL



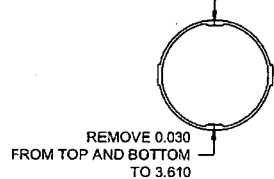
DETAIL K
SCALE 4X



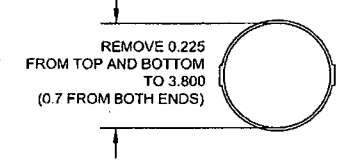
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



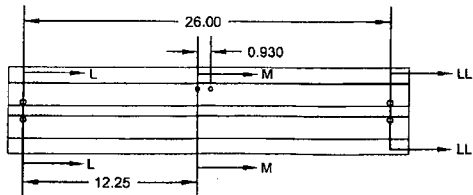
SECTION X-X
SCALE 5X



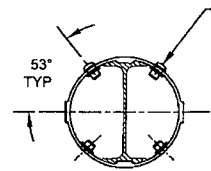
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

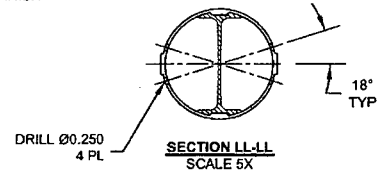
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



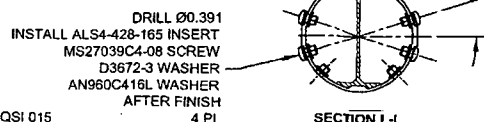
DETAIL E
SCALE NONE



SECTION M-M
SCALE 5X



SECTION LL-LL
SCALE 5X



SECTION L-L
SCALE 5X

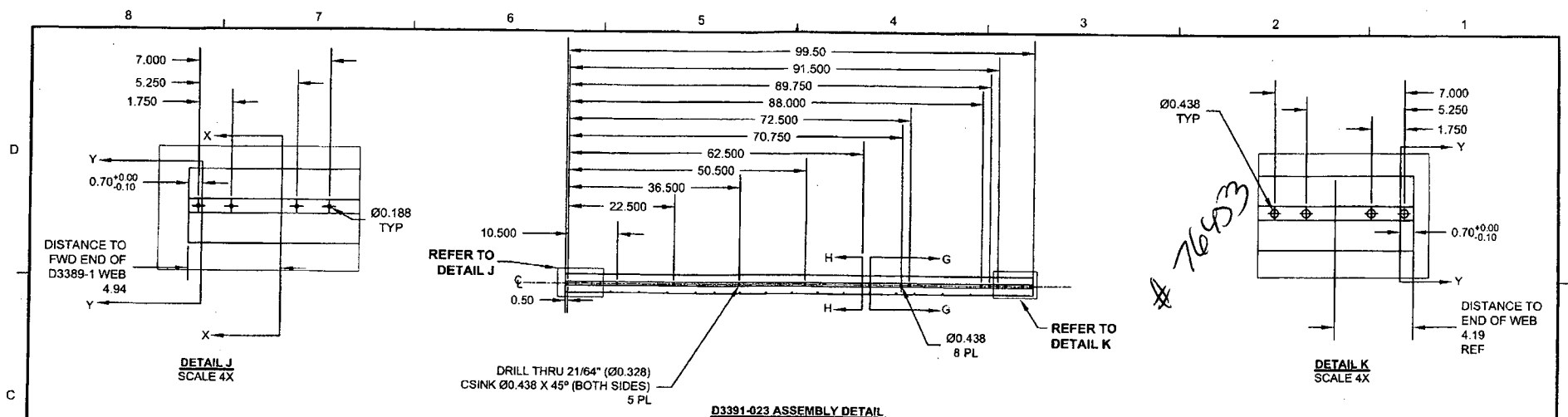
D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

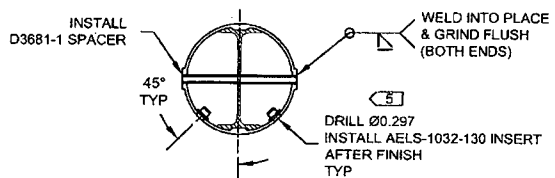
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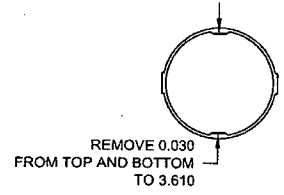
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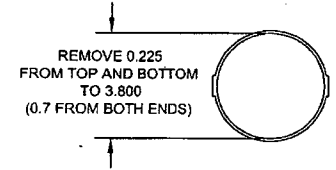
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

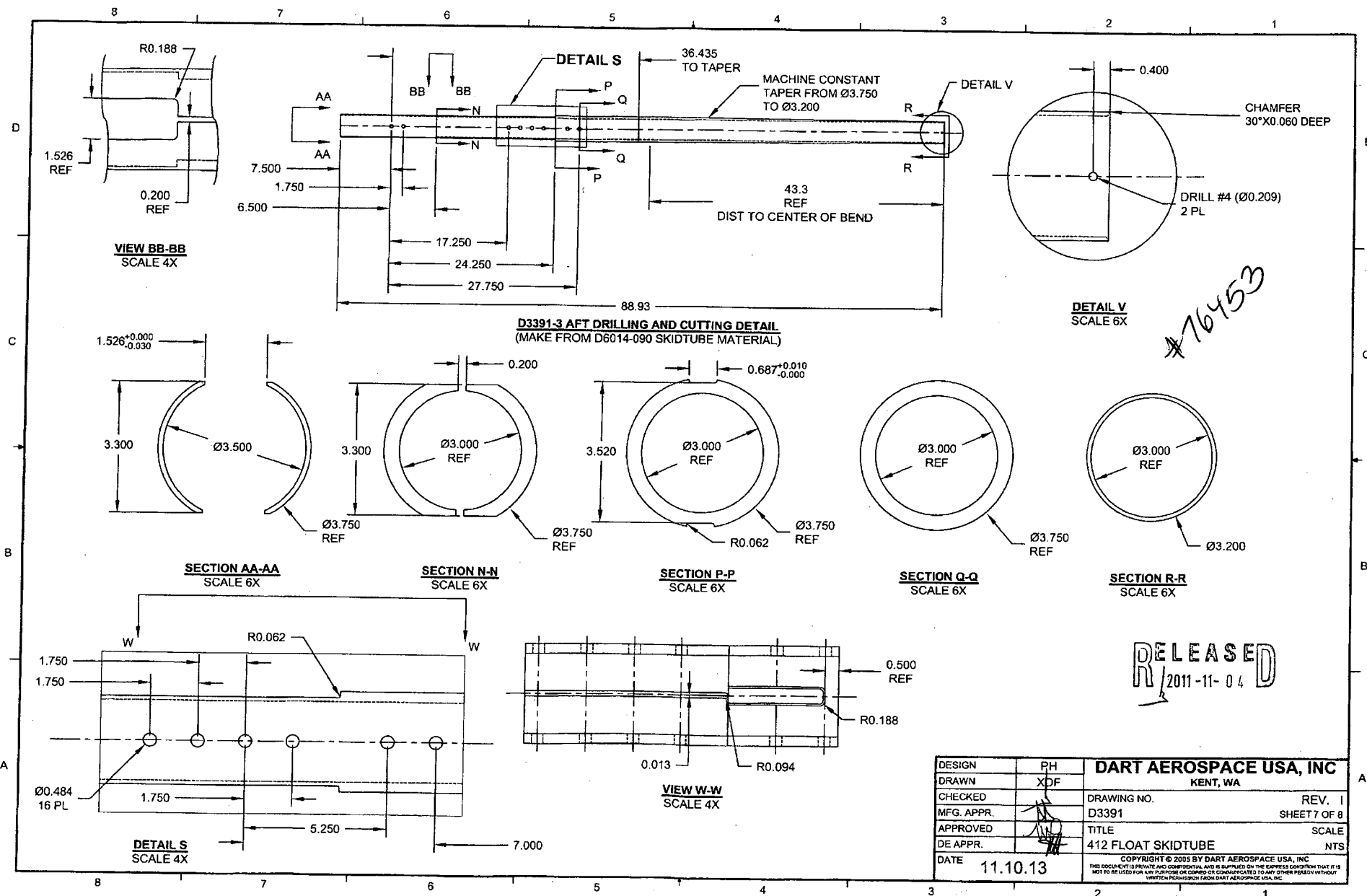
D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

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